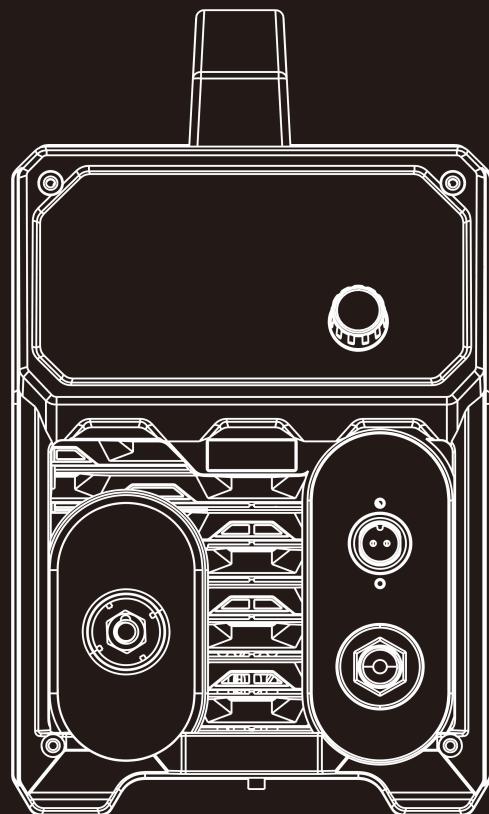




Just weld and cut

## Plasma Cutter Operation Manual



**RBC4000 PUMP**



Just weld and cut



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 Ins	weldflowhub

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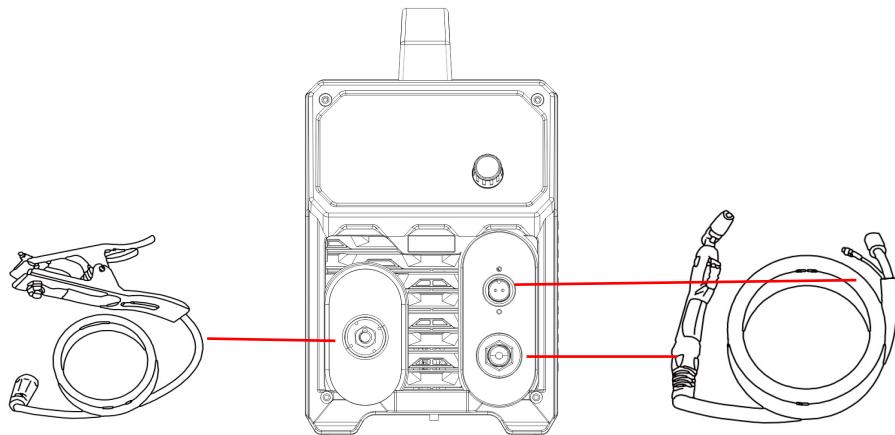
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# 1. Product Brief Introduction

 Model	RBC4000 PUMP	 Input Voltage	AC120 50-60Hz	 Circuit Breaker	120V:55A
 Duty Cycle	20%	 Current Range	15-45A	 Voltage Range	86-98V
 Efficiency	75%	 Protection Class	IP21S	 Power Factor	0.73
 No-Load Voltage	300V	 Rated Power	5.2KVA	 Weight (Kg)	12.5KG
 Insulation Class	H	 Size (mm)	420*175*300mm	 Air flow	0.8Mpa
 1.0mm	 120V-40A				
 Clear	 5Clear		 5max		
 Fe	8mm		12mm		
 Ss	8mm		12mm		
 Al	5mm		10mm		
 Cu	5mm		10mm		

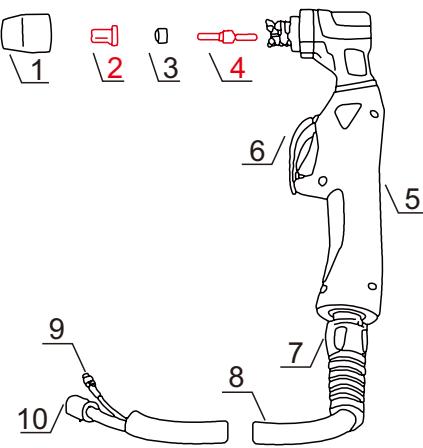
## 2. Accessories list

### 2.1 Touch Arc RBC4000 PUMP

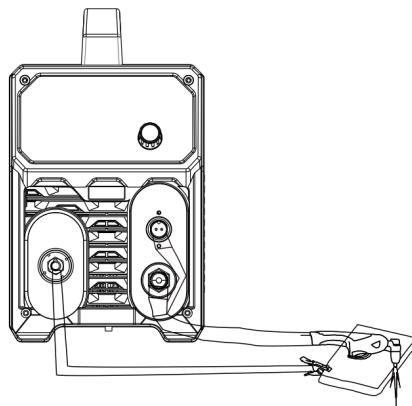


### PT31 Gun

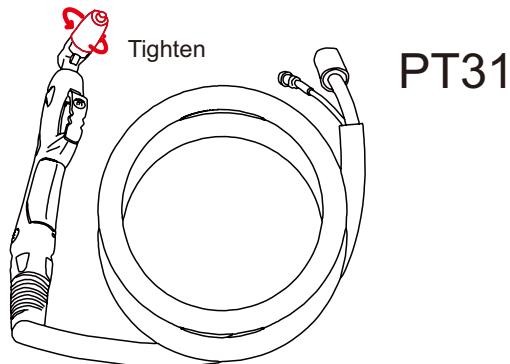
Replace Parts:2,4



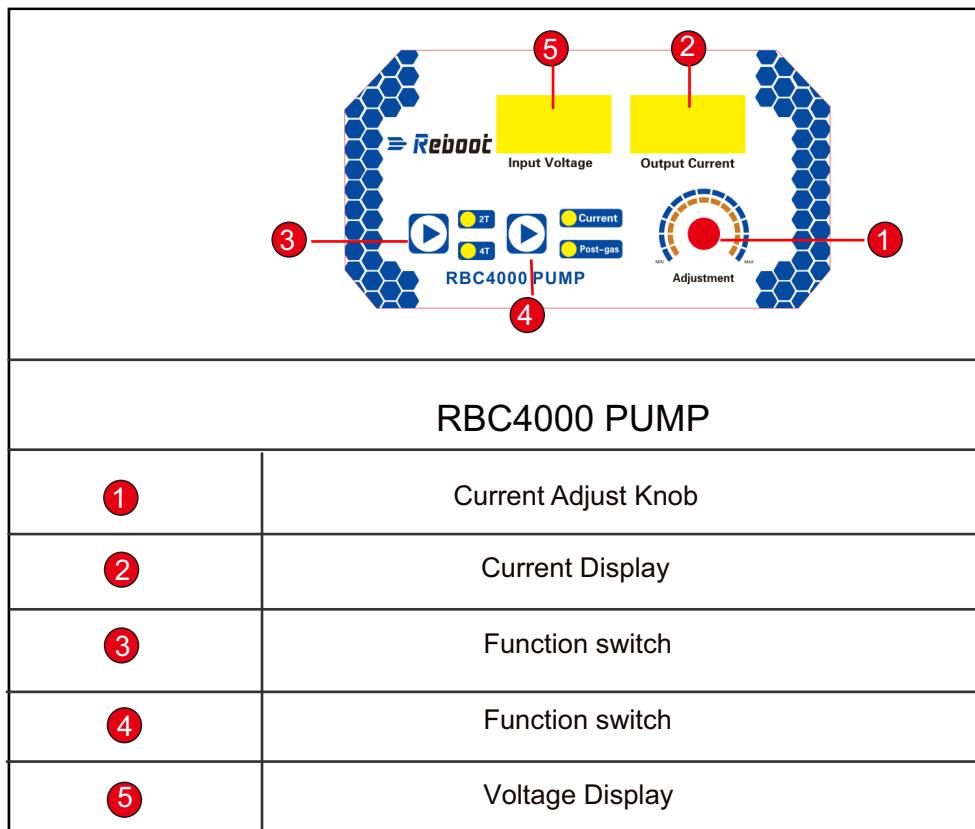
#### 3.1 Touch ARC



#### 3.2 Attention

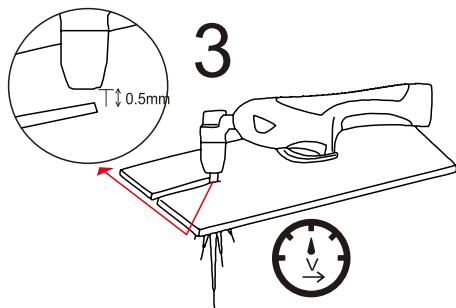
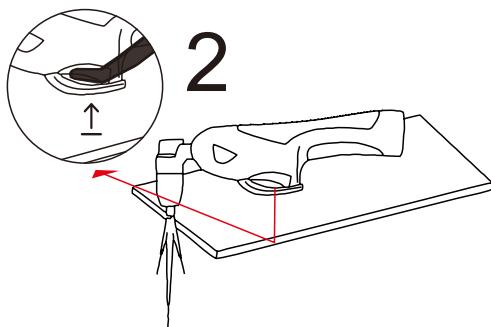
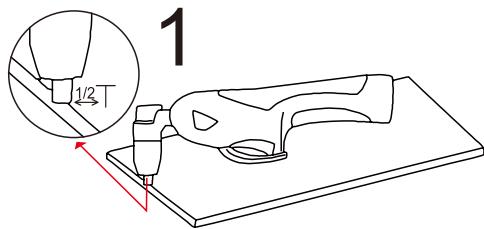


## 4. Operation panel interface

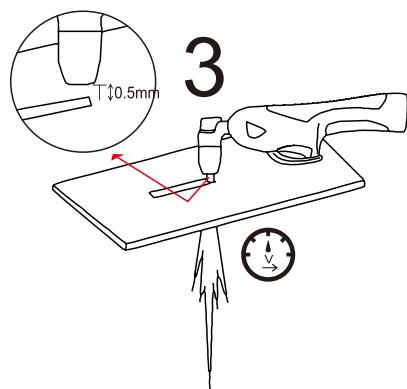
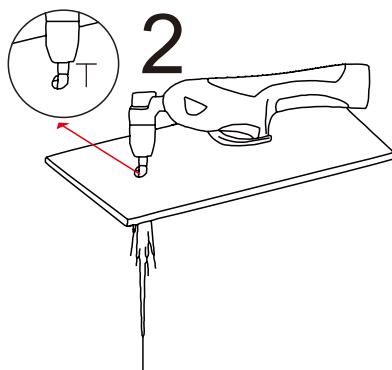
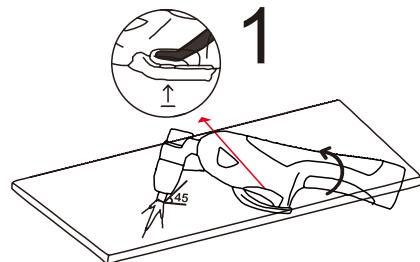


## 5. Start Cutting

### 5.1 Edge cutting

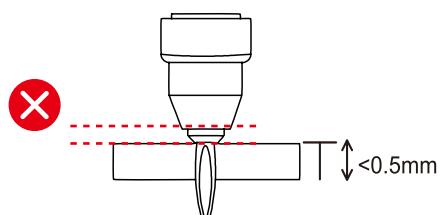
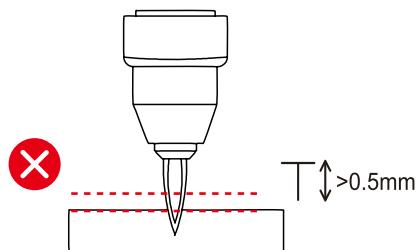
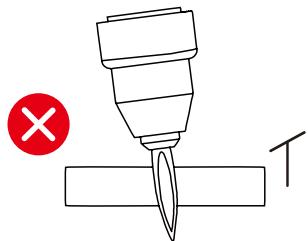
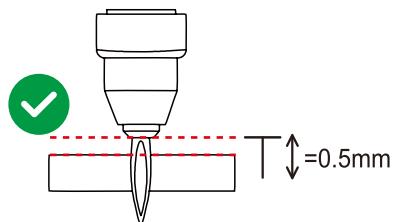


### 5.2 Piercing Cutting

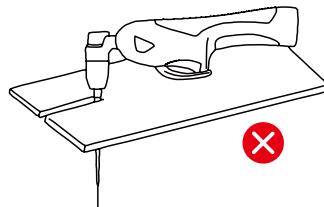
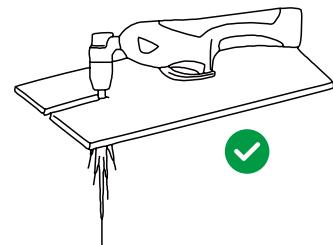
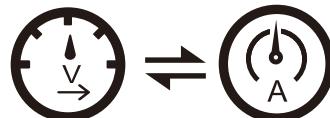


## 6. Hand torch cutting Show

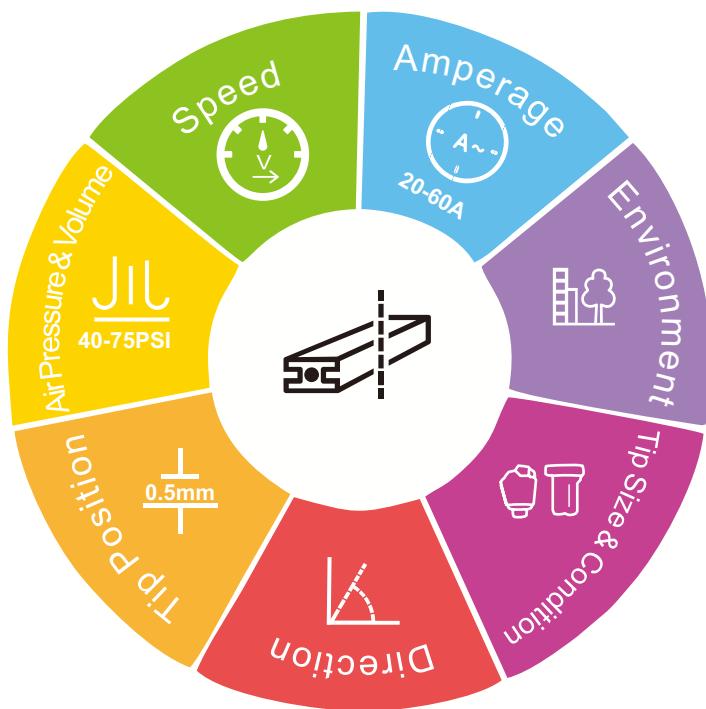
### 6.1 Torch tip height & position



### 6.2 Speed and Amperage



## 7. Cutting Performance Impact



<b>WARNING</b>	
<b>Do Not Remove, Destroy, Or Cover This Label.</b>	
 <b>ELECTRIC SHOCK</b> can kill <ul style="list-style-type: none"><li>• Wear dry protective apparel</li><li>• Avoid contacting work piece or ground</li><li>• Avoid contact with electrically live parts</li><li>• Do not touch work piece and welding wire at the same time</li><li>• Use only recommended cables and cords</li><li>• Connect ground clamp as close to the welding area as possible</li><li>• Disconnect power when servicing this welder</li></ul>	 <b>FIRE HAZARD</b> <ul style="list-style-type: none"><li>• Remove all flammable materials within 35 feet of the cutting arc</li><li>• Keep flying sparks from entering cracks or hidden areas</li><li>• Keep a fire extinguisher close</li><li>• Wear oil-free garments without pockets or cuffs</li><li>• Do not weld on closed containers</li></ul>
 <b>FUMES AND GASES</b> can injure your health <ul style="list-style-type: none"><li>• Do not breathe fumes emitted by the welding process</li><li>• Do not weld coated or plated materials(galvanized, cadmium, zinc, mercury, barium)</li><li>• Use ventilator when necessary</li><li>• Know the danger of materials you are welding</li><li>• Refer to MSDS sheets for welding wire and materials being welded</li></ul>	 <b>ARC RAYS</b> can injure eyes and burn <ul style="list-style-type: none"><li>• Always wear a helmet with full face and neck protection with shade#10 lens</li><li>• Use helmet that meets ANSI standards</li><li>• Wear correct eye, ear, and body protection</li><li>• Warn people in the cutting area when you are staring an arc</li></ul>
<b>Read the operator's manual for more safety information</b>	 <b>PLASMA ARC CAN CAUSE INJURY</b> <ul style="list-style-type: none"><li>• Use torch(es) specified in instruction manual</li><li>• Disconnect power source before disassembly of the torch</li><li>• The shield cup must be installed prior to operation of the torch</li><li>• Do not point plasma torch at body parts</li><li>• Do not hold material near cutting path</li><li>• Keep clear of torch tip while in use</li></ul>
	 <b>MAGNETIC FIELDS</b> <ul style="list-style-type: none"><li>• Keep people with pace makers away from your cutting area</li><li>• Keep PLASMA torch and ground cables on the same side of your body</li><li>• Do not wrap cable around your body while cutting</li></ul>

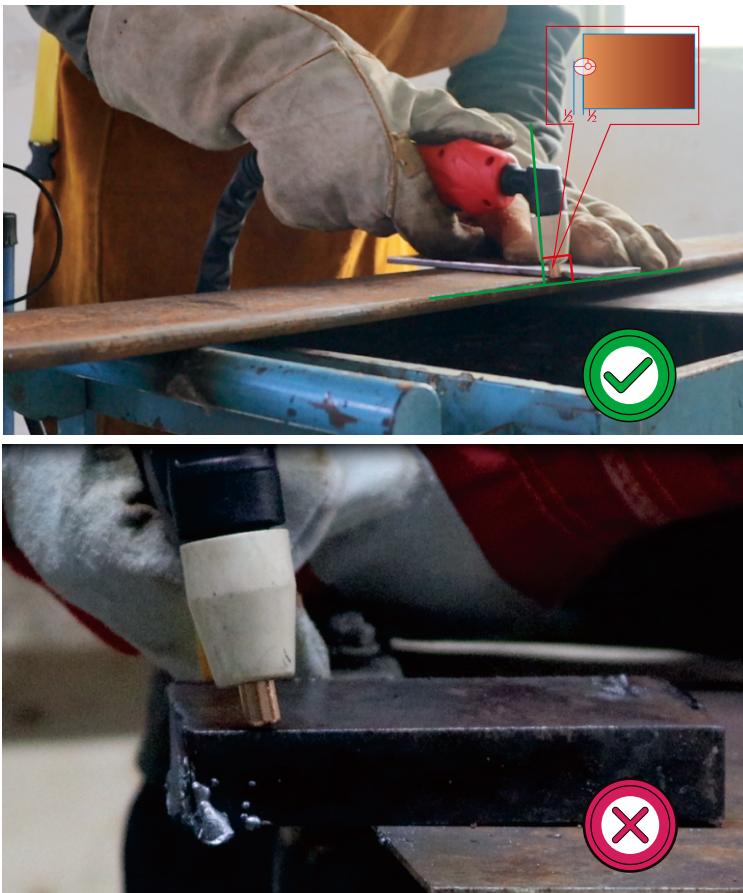
## 8. Cutting Guide

1. Rest assured, 95% of all issues with the operation of the machine can be resolved by following the steps below.

2. Three key points for using a cutting machine. Beginners are advised to start with cutting thin sheets and practice more.

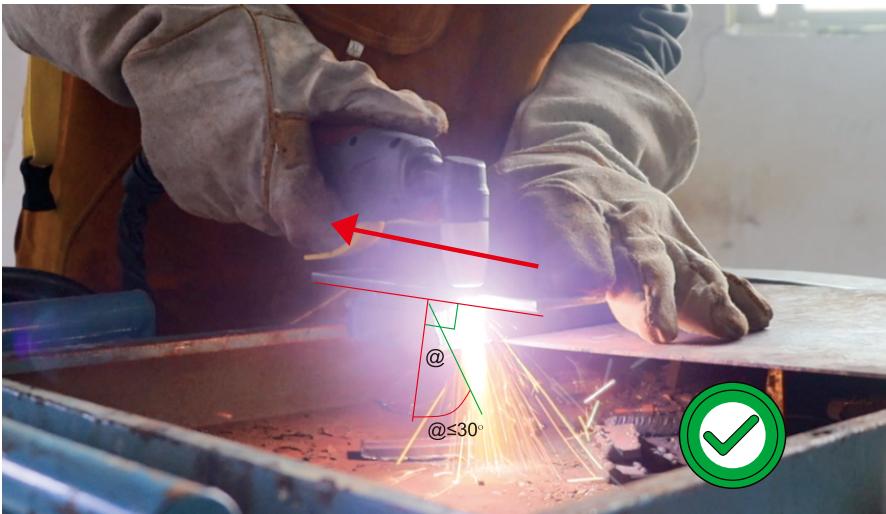
### Before cutting:

1. Ensure the torch head is perpendicular to the workpiece.
2. Position the midpoint of the holes in the nozzle in line with the edge of the workpiece.
3. Start the arc by pressing the torch trigger and move slowly forward, stopping the torch head until the cutting arc is as vertical as possible before proceeding.
4. If the cut isn't penetrating, slow down the torch movement and try cutting again elsewhere.
5. It's normal for beginners to struggle at first, so start with thinner plates, around 3mm.



### During cutting:

- 1.Keep the torch head perpendicular to the workpiece throughout the cutting process.
- 2.Ensure the angle of the downward spark spray is no more than 30 degrees from vertical.
- 3.Slow down the torch movement if the angle is too large until it's less than 30 degrees.
- 4.If there's a spark spray back, stop cutting and restart from a new point.



## 8. Cutting Guide

### Ending Cutting:

- 1.Pause the torch momentarily when reaching the end of the workpiece,waiting for the cutting arc to become as vertical as possible and the edge of the workpiece to turn red before slowly moving the torch forward to complete the cut.
- 2.If there's a spark spray back, pause cutting immediately to avoid damaging the torch parts.
- 3.It's normal for beginners to experience spark spray back,so prepare extra parts and practice more.



### 3. Pay attention to timely replacement of vulnerable parts.

#### ① Fitting



If the Hafnium wire at the electrode tip is Deformed nozzles must be replaced recessed by 2mm, replace the electrode; Electrode both ends can be used.



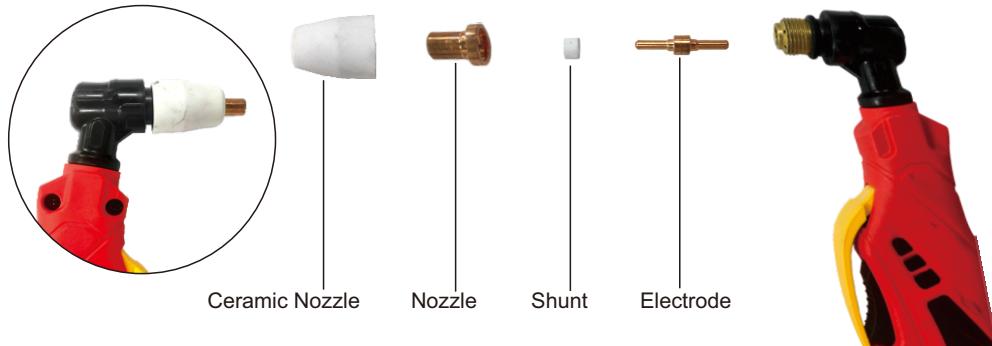
Scan to buy consumables on shops



## 8. Cutting Guide

### ② cutting torch setup

#### PT31 Setup





Advanced welding and cutting technology,  
leading the industry trend.